

Date: Monday, 11/08/2008 1:04:06 PM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 412 SKI WEARPLATE	
Job Number	: 41111		Part Number	: D3796041	
Estimate Number	: 13542		Drawing Number	: D3796 REV.A PREL	
P.O. Number	:		Project Number	: N/A	
This Issue	: 11/08/2008	S.O. No. :	Drawing Revision	: PRELIM	
Prsht Rev.	:	NC	Material	:	
First Issue	:	/ /	Due Date	: 18/08/2008	Qty: 3 Um: Each
Previous Run	: 41009				
Written By	:				
Checked & Approved By	: <u>MF 08-08-11</u>				
Comment	: Est Rev:A 08-08-05 new issue DD verified by:ec				

## Additional Product

**PRELIMINARY ISSUE**

Job Number:	
Seq. #:	Machine Or Operation:
1.0	M304S16GA
	
Comment: Qty.: 2.0769 sf(s)/Unit Total: 6.2307 sf(s)	
NEOPRENE SHEET 0.063 <u>304</u> batch: <u>108734</u> <u>HB 8-8-11</u>	(6) (3)
2.0	WATER JET
	
Comment: FLOW WATER JET	
1-Cut as per Dwg D3796	(6)
Dwg Rev: <u>PRF</u>	(3)
Prog Rev: <u>PRF</u> <u>HB 8-8-11</u>	(3)
2-Deburr if necessary	<u>HB 8-8-11</u>
3.0	QC2
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
HB 8-8-11	(6) (3)
4.0	QC8
	
Comment: SECOND CHECK	
<u>HB 8-8-11</u>	(3) (6)
5.0	D30093
	
Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)	
Cup	(6)
batch: <u>041075</u> ✓ <u>12x 41176-1</u> ✓	<u>08-08-14</u>

LAST  
page

Date: Monday, 11/08/2008 1:04:06 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 SKI WEARPLATE

Job Number: 41111

Part Number: D3796041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

08-08-14

(2)

Weld hardcoat and cups as per dwg D3796

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-15 (2)

ENGINEERING  
APPROVAL

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-08-15 (2)

08-08-20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Spec

Location: 41077

41077

8/8/18

6  
2

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/09 (2)

08-08-20

Job Completion



POSITIVE RECALL

EFFECTIVE 08-08-18

AUTH 11

RELEASED

DATE 08-08-18

08-08-18

08-08-18

08-08-08

Perm. Change  
08-08-18

**ENGINEERING CHANGE NOTICE**  
**DART AEROSPACE LTD**

Date: 08.08.05	Job No.: 00245	ADR Yes/No: <input checked="" type="checkbox"/> N	ADR Date: N/A	ECN #: 08- 509P
Product No.: D412-777		Created By: <i>BB</i>	Approved By: <i>BB</i>	
Product Name: BEARPAW SKIS		Checked By: <i>BB</i>	General Manager Approval: <i>BB</i>	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	
Production Document Control	N		
Customer Technical Support	N		

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change:

MANUFACTURING OF WEARPLATES FOR BEARPAW SKIS - PARTS WILL BE SHIPPED TO AUTRIAN ARMY FOR FIT & FUNCTION TEST

Documents Affected:

RELEASE PRELIM ISSUE OF D3796 REV. A

**REFERENCE ONLY**

**PARTS MUST COMPLY**

**PREVIOUS PARTS SATISFACTORY**

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	N			
9	Update Blue/Pink/DSI Folder and Electronic Files	N			
10	Update Controlled PDF Files	N			
11	Update Master Document List (MDL)	N			
12	Update Document Record (DR)	N			
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	Y	KJ	CREATE PARTS IN ACCPAC	
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	N			
18	Create / Update PPP's	N			
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	N			
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	N			
22					
23					

Description / Action:

MANUFACTURE 2 EACH OF D3796-041/043 FOR AUSTRIAN FIT & FUNCTION INSTALLATION TEST.

RETURN PARTS TO ENGINEERING AFTER COMPLETION.

ECN Verified & Complete: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD

**Work Order:** 41111

**Description:** 412 SKI WING PLATE

**Part Number:** D3196-1

Inspection Dwg: D3796-1 Rev: D.R.F.

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Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article Prototype

**Measured by:**

13

**Audited by:**

### **Prototype Approval:**

Date: \_\_\_\_\_

8-8-11

Date:

2/14

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/08/15	2-0	I part taken <del>as</del> to make as weld pattern template. for DT 9040	/	08/08/15	1	BS1042	08/08/15

Part No: D3796-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/08/15  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

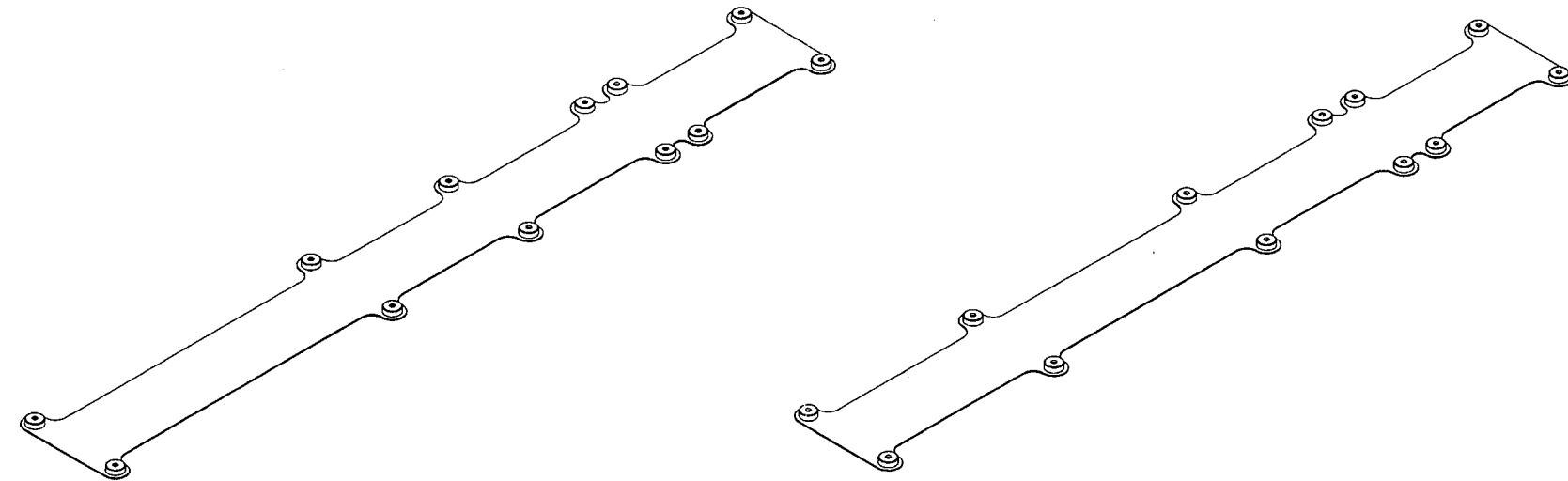
NCR: 4111		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/15	6-0	Qty 6 parts scrap. Parts warped during welding & no longer fit into the ass'y.	/	create a weld sig. DT 9040	/ 08/08/15	/	/	/
		R.C: No welding sig to hold the parts true to maintain the shape.		Scrap; destroy the parts.	08/08/15	/	/	/

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



D3796-041 FWD WEARPLATE WELDMENT

D3796-043 AFT WEARPLATE WELDMENT

RELEASED  
08-08-01

A	NEW ISSUE	MB	08.08.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>		
DRAWN			
CHECKED	<i>AS</i>		
MFG. APPR.	<i>NA</i>		
APPROVED	<i>AS</i>		
DE APPR.	<i>NA</i>		
DATE	08.08.01	SCALE	NTS
		DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. A
		D3796	SHEET 1 OF 4
		TITLE	
		412 SKI WEARPLATE	

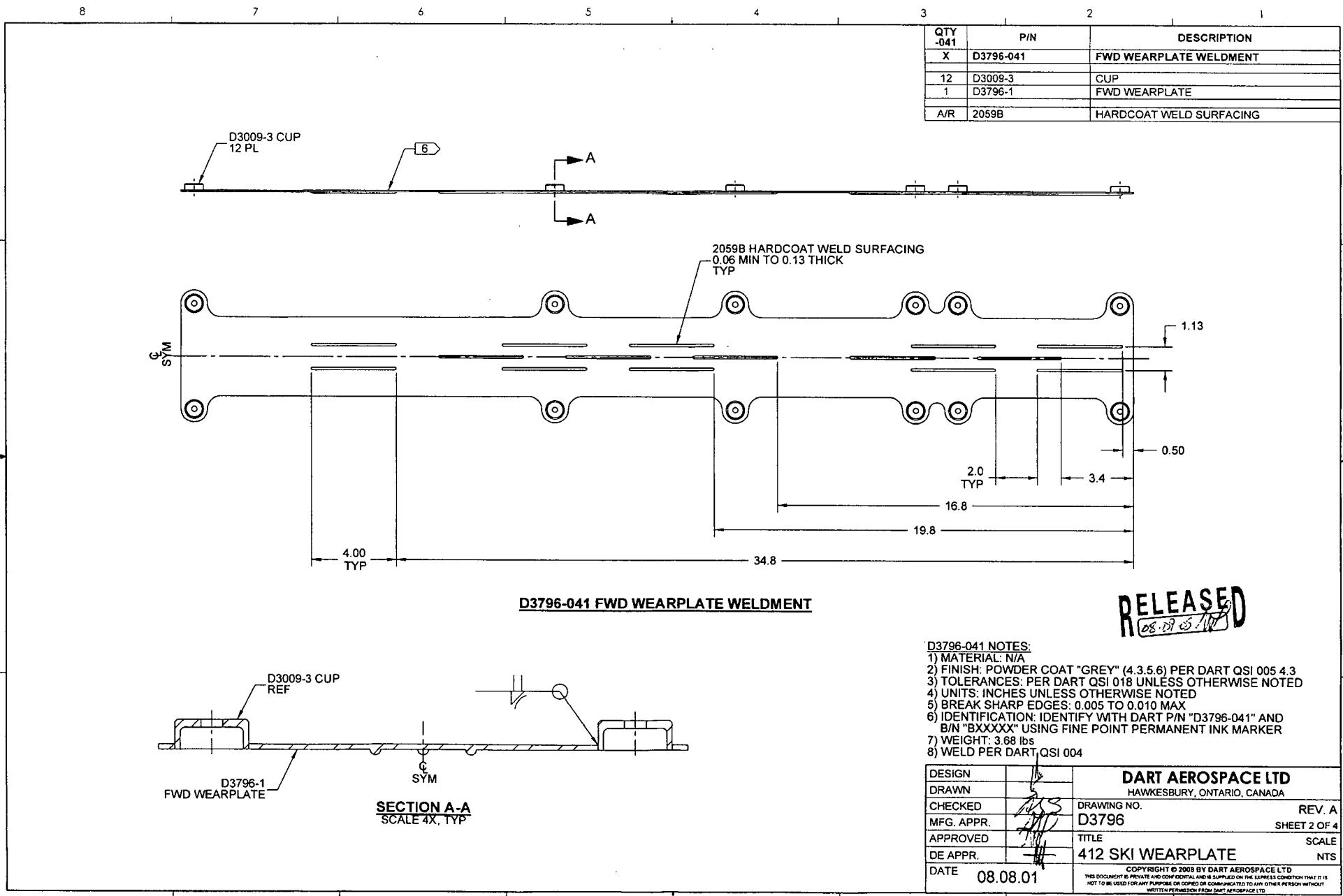
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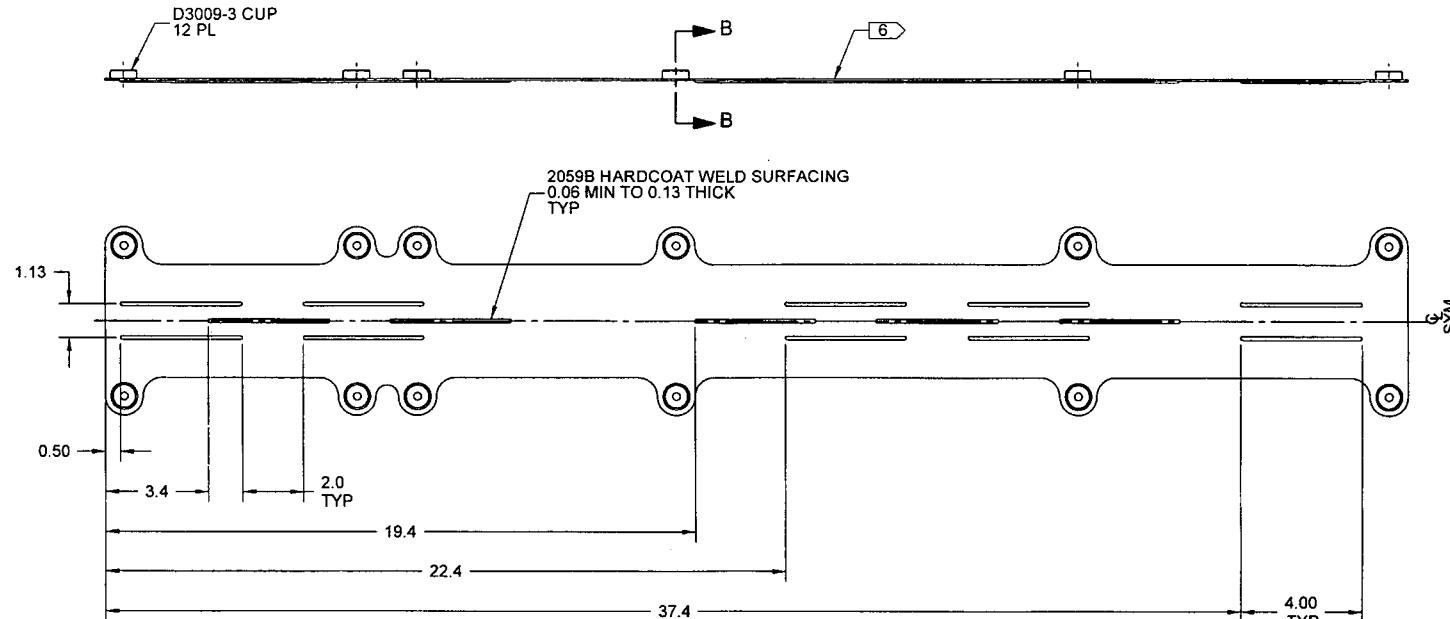
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A

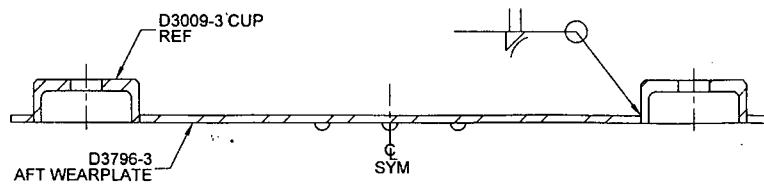
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QTY -043	P/N	DESCRIPTION
X	D3796-043	AFT WEARPLATE WELDMENT
12	D3009-3	CUP
1	D3796-3	AFT WEARPLATE
A/R	2059B	HARDCOAT WELD SURFACING



**D3796-043 AFT WEARPLATE WELDMENT**



**SECTION B-B**

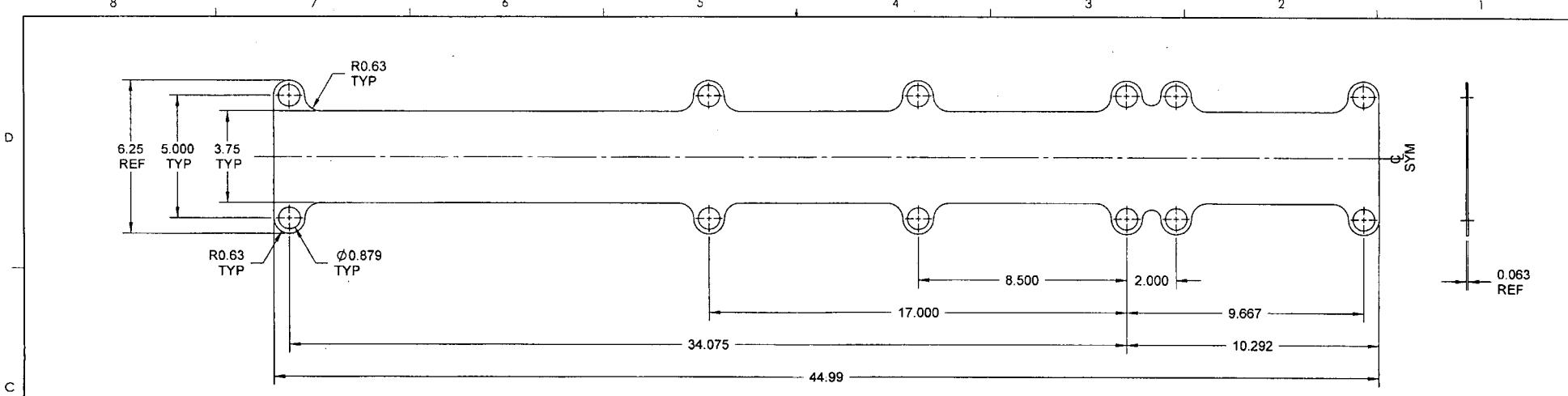
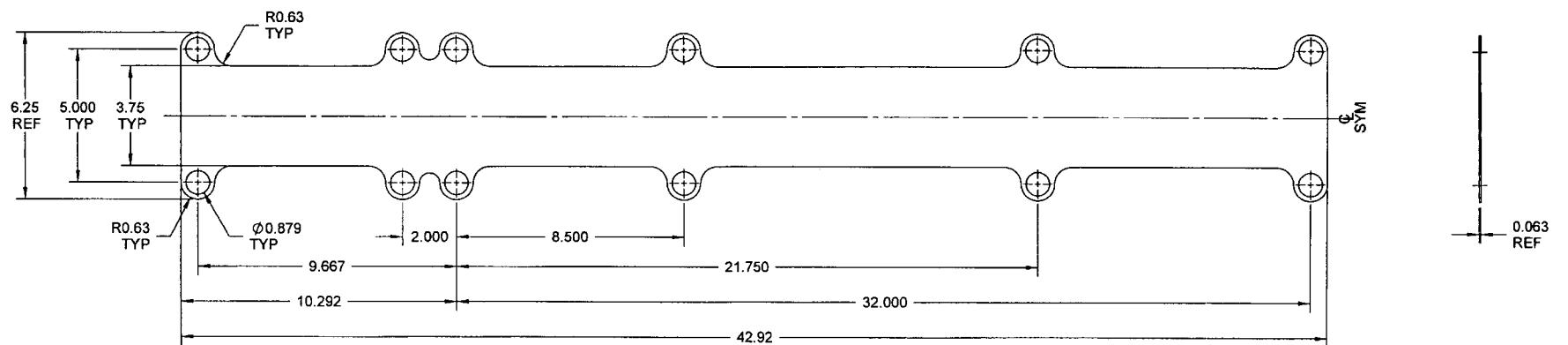
D3796-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3796-043" AND B/N "BXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.54 lbs
- 8) WELD PER DART QSI 004

DESIGN	15	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	103	DRAWING NO.	REV. A
MFG. APPR.	11	D3796	SHEET 3 OF 4
APPROVED	11	TITLE	SCALE
DE APPR.	11	412 SKI WEARPLATE	NTS
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8 7 6 5 4 3 2 1

D3796-1 FWD WEARPLATED3796-3 AFT WEARPLATE

## D3796-1/3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:  
D3796-1 = 3.25 lbs  
D3796-3 = 3.11 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>b</i>
DRAWN	<i>AS</i>
CHECKED	<i>AS</i>
MFG. APPR.	<i>AS</i>
APPROVED	<i>AS</i>
DE APPR.	<i>AS</i>
DATE	08.08.01

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HAWKSLEY, ONTARIO, CANADA

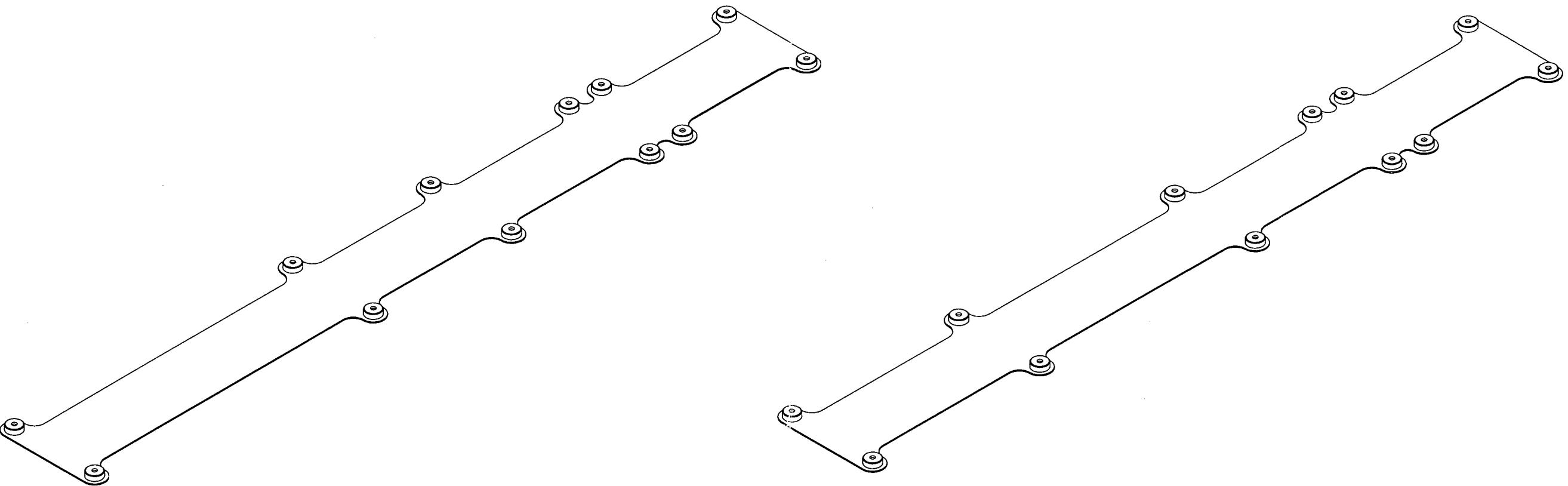
DRAWING NO. D3796 REV. A  
SHEET 4 OF 4

TITLE 412 SKI WEARPLATE NTS

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**RELEASED**  
*08-09-03*

8 7 6 5 4 3 2 1



D3796-041 FWD WEARPLATE WELDMENT

D3796-043 AFT WEARPLATE WELDMENT

**PRELIMINARY ISSUE**

08.08.05

FOR ECN # 08-509P

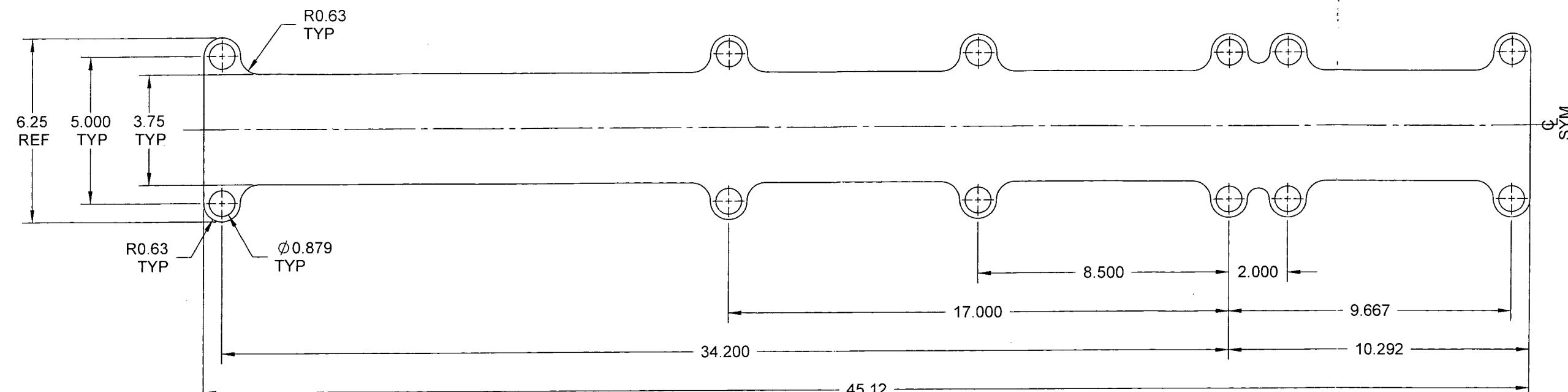
A	NEW ISSUE	MB	08.08.01
REV.	DESCRIPTION	BY	DATE
DESIGN	15		
DRAWN	15		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.01		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

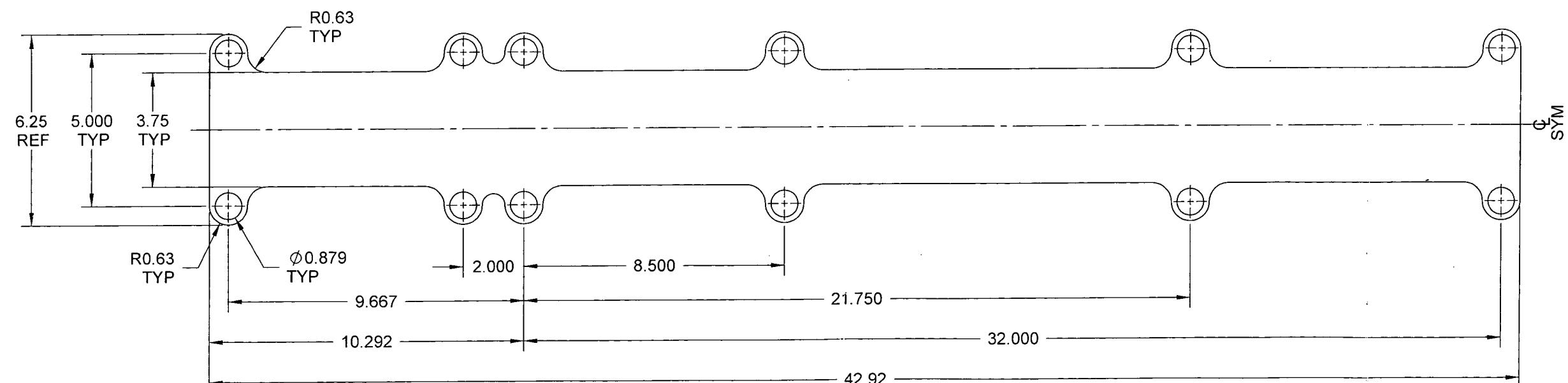
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SHEET 1 OF 4

SCALE  
NTS

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**D3796-1 FWD WEARPLATE**



**D3796-3 AFT WEARPLATE**

**D3796-1/-3F NOTES**

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S16GA)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT:  
D3796-1 = 3.26 lbs  
D3796-3 = 3.11 lbs

# PRELIMINARY ISSUE

08.08.07  
88-701#08-519P

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

HAWTHORPE, ONTARIO, CANADA

NO. 1

SHEET

## KI WEARPLATE

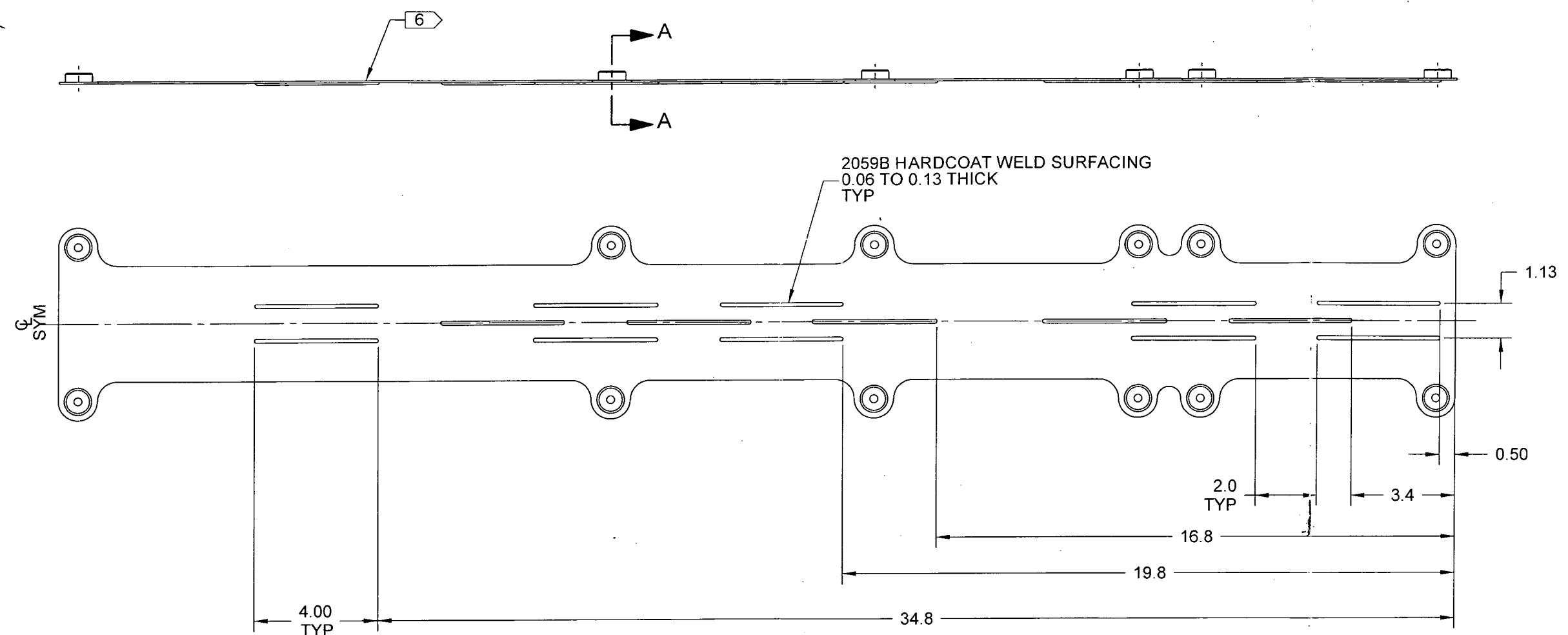
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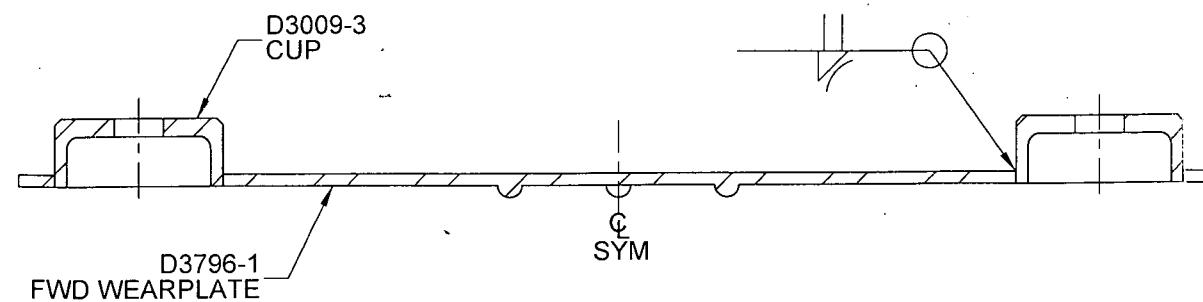
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QTY	P/N	DESCRIPTION
-041		
X	D3796-041	FWD WEARPLATE WELDMENT
12	D3009-3	CUP
1	D3796-1	FWD WEARPLATE



### D3796-041 FWD WEARPLATE WELDMENT



**SECTION A-A**  
SCALE 4X, TYP

**PRELIMINARY ISSUE**

08.08.01  
PER ECU # 08-509P

#### D3796-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3796-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.69 lbs
- 8) WELD PER DART QSI 004

DESIGN	15	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	15	
CHECKED	15	
MFG. APPR.	1	
APPROVED	1	
DE APPR.	1	
DATE	08.08.01	

REV. A  
SHEET 2 OF 4  
SCALE  
NTS  
TITLE  
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